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D3294-1

Job Sheet 213617



Part No: D3294-1

Job Qty: 10 pcs

DAS
21
9-88

Part Name: Bracket For Interior Window For -115



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/20

Job Tracking No:

Due Date: 10/16/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs			0.17	3.21	Waterjet - Flow		02/20/10/08
110	QC 2	10 pcs			0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		02/20/10/08
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	10 pcs	0.00 0.00	QC 2 - 65	
			QC 2 - 5	
			QC 2 - 71	
			QC 2 - 73	
			QC 2 - 69	
			QC 2 - 76	
			QC 2 - 86	
			QC 2 - 83	
			QC 8 - 12	
			QC 8 - 14	
			QC 8 - 17	
			QC 8 - 20	
			QC 8 - 25	
			QC 8 - 3	
			QC 8 - 32	
			QC 8 - 33	
			QC 8 - 35	
			QC 8 - 39	
			QC 8 - 4	
			QC 8 - 44	
			QC 8 - 45	
			QC 8 - 49	
			QC 8 - 58	
			QC 8 - 8	
			QC 8 - 9	
			QC 8 - 68	
			QC 8 - 67	
			QC 8 - 1 (A)	
			QC 8 - 47	
			QC 8 - 40	
			QC 8 - 52	
			QC 8 - 23	
			QC 8 - 57	
			QC 8 - 76	
			QC 8 - 61	
			QC 8 - 66	
			QC 8 - 73	
			QC 8 - 82	
130 Small Fab - Brake NC - B4B	10 pcs	0.25 1.38	Small Fab - Brake - 1 - B4B	
			Small Fab - Brake - 2 - B4B	
			Small Fab - Brake - 3 - B4B	
140 QC 5	10 pcs	0.00 0.00	QC 5 - 10	
			QC 5 - 12	
			QC 5 - 17	
			QC 5 - 18	
			QC 5 - 19	
			QC 5 - 22	
			QC 5 - 24	
			QC 5 - 3	
			QC 5 - 43	
			QC 5 - 49	
			QC 5 - 51	
			QC 5 - 58	
			QC 5 - 68	
			QC 5 - 9	
			QC 5 - 50	
			QC 5 - 30	

DAS

40

9-89

OCT 08 2020

OCT 09 2020

			QC 5 - 40	OCT 09 2020
			QC 5 - 61	
			QC 5 - 81	
			QC 5 - 82	
150 Handfinish - 1-1 Chemical-B4B	10 pcs	0.00 0.76	Handfinish - 1 - 1 - B4B	
			Handfinish - 1 - 2 - B4B	
			Handfinish - 1 - 3 - B4B	
			Handfinish - 1 - 4 - B4B	
			Handfinish - 1 - 5 - B4B	
			Handfinish - 1 - 6 - B4B	
			Handfinish - 1 - 7 - B4B	
			Handfinish - 1 - 8 - B4B	
			Handfinish - 1 - 9 - B4B	
			Handfinish - 1 - 10 - B4B	
			Handfinish - 1 - 11 - B4B	
			Handfinish - 1 - 12 - B4B	
			Handfinish - 1 - 13 - B4B	
			Handfinish - 1 - 14 - B4B	
			Handfinish - 1 - 15 - B4B	
			Handfinish - 1 - 16 - B4B	
			Handfinish - 1 - 17 - B4B	
			Handfinish - 1 - 18 - B4B	
			Handfinish - 1 - 19 - B4B	
			Handfinish - 1 - 20 - B4B	
			Handfinish - 1 - 21 - B4B	DAS
			Handfinish - 1 - 22 - B4B	47 OCT 15 2020
160 QC 7	10 pcs	0.00 0.00	QC 7 - 10	9-89
			QC 7 - 13	
			QC 7 - 14	
			QC 7 - 15	
			QC 7 - 17	
			QC 7 - 18	
			QC 7 - 19	
			QC 7 - 2	
			QC 7 - 28	
			QC 7 - 3	
			QC 7 - 30	
			QC 7 - 34	
			QC 7 - 36	
			QC 7 - 37	
			QC 7 - 41	
			QC 7 - 47	
			QC 7 - 48	
			QC 7 - 51	
			QC 7 - 58	
			QC 7 - 59	
			QC 7 - 60	
			QC 7 - 9	
			QC 7 - 68	
			QC 7 - 50	
			QC 7 - 67	
			QC 7 - 40	
			QC 7 - 24	
			QC 7 - 43	
			QC 7 - 61	
			QC 7 - 81	
			QC 7 - 76	
			QC 7 - 79	
			QC 7 - 83	

OCT 15 2020

			QC 7 - 82	DAS 81	
			QC 7 - 87	9-89	
170 Small Fab - 2 - B4B	10 pcs	0.00 1.57	Small Fab - 1 - B4B		OCT 29 2020
			Small Fab - 2 - B4B		
			Small Fab - 3 - B4B	DAS	
			Small Fab - 4 - B4B	58	
			Small Fab - 5 - B4B	9-89	
			Small Fab - 6 - B4B		
			Small Fab - 7 - B4B		
			Small Fab - 8 - B4B		
			Small Fab - 9 - B4B		
			Small Fab - Various 1 - B4B		
180 QC 5	10 pcs	0.00 0.00	QC 5 - 10		
			QC 5 - 12		
			QC 5 - 17		
			QC 5 - 18		
			QC 5 - 19		
			QC 5 - 22		
			QC 5 - 24		
			QC 5 - 3		
			QC 5 - 43		
			QC 5 - 49		
			QC 5 - 51		
			QC 5 - 58		
			QC 5 - 68		
			QC 5 - 9		
			QC 5 - 50		
			QC 5 - 30		
			QC 5 - 40	DAS 40	OCT 29 2020
			QC 5 - 61	9-89	
			QC 5 - 81		
			QC 5 - 82		
190 Powdercoat - 4 Black Sand - B4B	10 pcs	0.00 0.44	Powdercoat - 1 - B4B		
			Powdercoat - 2 - B4B		
			Powdercoat - 3 - B4B		20-10-30
			Powdercoat - 4 - B4B		
			Powdercoat - 5 - B4B		
			Powdercoat - 6 - B4B		
			Powdercoat - 7 - B4B		
			Powdercoat - 8 - B4B		
			Powdercoat - 9 - B4B		
			Powdercoat - 10 - B4B		
200 QC 3	10 pcs	0.00 0.00	QC 3 - 10		
			QC 3 - 13		
			QC 3 - 15		
			QC 3 - 17		
			QC 3 - 18		
			QC 3 - 2		
			QC 3 - 28		
			QC 3 - 3		
			QC 3 - 30		
			QC 3 - 34		
			QC 3 - 36		
			QC 3 - 41		
			QC 3 - 51		
			QC 3 - 58		
			QC 3 - 59		
			QC 3 - 68		

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			QC 3 - 9	
			QC 3 - 40	
			QC 3 - 19	
			QC 3 - 43	
			QC 3 - 24	
			QC 3 - 61	
			QC 3 - 81	DAS 81
			QC 3 - 82	9-89
			QC 3 - 87	
			QC 3 - 47	
				OCT 30 2020
210 Packaging 3-1 - Stock - B4B	10 pcs 8 pcs M/D	0.00 0.00	Packaging 3 - 1 - B4B	
			Packaging 3 - 2 - B4B	
			Packaging 3 - 3 - B4B	
			Packaging 3 - 4 - B4B	
			Packaging 3 - 5 - B4B	DAS 28
			Packaging 3 - 6 - B4B	9-89
			Packaging 3 - 7 - B4B	
			Packaging 3 - 8 - B4B	NOV 02 2020
			Packaging 3 - 9 - B4B	
			Packaging 3 - 10 - B4B	
			Packaging 3 - 11 - B4B	
			Packaging 3 - 12 - B4B	
			Packaging 3 - 13 - B4B	
			Packaging 3 - 14 - B4B	
			Packaging 3 - 15 - B4B	
			Packaging 3 - 16 - B4B	
			Packaging 3 - 17 - B4B	
			Packaging 3 - 18 - B4B	
			Packaging 3 - 19 - B4B	
			Packaging 3 - 20 - B4B	
			Packaging 3 - 21 - B4B	
			Packaging 3 - 22 - B4B	
			Packaging 3 - 23 - B4B	
			Packaging 3 - 24 - B4B	
			Packaging 3 - 25 - B4B	
			Packaging 3 - 26 - B4B	
			Packaging 3 - 27 - B4B	
			Packaging 3 - 28 - B4B	
			Packaging 3 - 29 - B4B	
			Packaging 3 - 30 - B4B	
			Packaging 3 - 31 - B4B	
			Packaging 3 - 32 - B4B	
			Packaging 3 - 33 - B4B	
			Packaging 3 - 34 - B4B	
			Packaging 3 - 35 - B4B	
			Packaging 3 - 36 - B4B	DAS 21
			Packaging 3 - 37 - B4B	9-89
220 QC 21 - SA	10 pcs	0.00 0.00	QC 21 - SA - 21	NOV 02 2020
			QC 21 - SA - 70	
			QC 21 - SA - 9	
			QC 21 - SA - 77	
			QC 21 - SA - 28	

Part Op 100 - 1-Cut as per Dwg D3294 Cut File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as
 Descriptions: per dwg** 2-Deburr if necessary
 110 - (QC2- Inspect parts off machine FAI/FAIB)
 120 - (QC8- Inspect parts - second check)
 130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)
 140 - (QC5- Inspect part completeness to step on W/O)
 150 - (Chemical Conversion Coat per QSI005 4.1)
 160 - (QC7-Inspect Chemical Conversion Coat)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

180 - QC5- Inspect part completeness to step on W/O)

190 - (Black Sandtex(Ref:4.3.5.7) per QSI005 4.3) Start Time: _____ Oven Temperature: _____ Finish Time: _____

200 - (QC3- Inspect Part Finish)

210 - (Identify as per dwg & Stock Location: _____)

220 - (QC21- Final Inspection - Work Order Release)

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	18 sf (1.8 ea)	100-Waterjet - Flow - 1	S216407
D3294-5	Doubler 129	10 pcs (1 ea)	170-Small Fab - 2 - B4B	S303PP
MS20470AD4-5	Rivet, Universal Head 009	150 Ea (15 ea)	170-Small Fab - 2 - B4B	S303PP SOS 1253

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	18	120	0
170-Small Fab - 2 - B4B	D3294-5	10	12	0
	MS20470AD4-5	150	728	0

Part Specifications

Specifications could not be found.

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DART AEROSPACE LTD		Work Order: 213617
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	Ø.128	1		Via-04	
Ø0.141	+0.005/-0.001	Ø.140	1		" "	
6.708	+/-0.010	6.709	1		" "	
1.118	+/-0.010	1.117	1		" "	
5.590	+/-0.010	5.591	1		" "	
1.118	+/-0.010	1.114	1		" "	
13.563	+/-0.010	13.563	1		Tap	
1.043	+/-0.010	1.042	1		Via-04	
0.625	+/-0.010	.626	1		" "	
0.325	+/-0.010	.329	1		" "	
0.300	+/-0.010	.300	1		" "	
0.400	+/-0.010	.401	1		" "	
6.000	+/-0.010	5.999	1		" "	
1.000	+/-0.010	.999	1		" "	
17.124	+/-0.010	17.124	1		Tap	
16.13	+/-0.030	16.13	1		"	
7.27	+/-0.030	7.27	1		"	
11.97	+/-0.030	11.97	1		"	
8.37	+/-0.030	8.37	1		"	
20.05	+/-0.030	20.05	1		"	
12.98	+/-0.030	12.98	1		"	
14.59	+/-0.030	14.59	1		"	
11.66	+/-0.030	11.66	1		"	
0.080	+/-0.010	.079	1		Via-04	

Measured by: <i>DA</i>	Audited by: <i>DAS</i>	Preliminary Approval:
Date: 20/10/08	Date: OCT 08 2020	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	<i>[Signature]</i>

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S305645



Part: D3294-1

Job No: 213617

Serial No/Batch: S305645

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Date: 10/08/20